

Date: Wednesday, 19/11/2008 9:57:54 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 206 STEP END PLATE		
Job Number	: 43535			Part Number	: D2734		
Estimate Number	: 11021			Drawing Number	: D2734 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 19/11/2008 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 28/11/2008 Qty: 200 Um: Each		
Previous Run	: 39179						
Written By	:						
Checked & Approved By	: <u>JUO 08-11-19</u>						
Comment	: Est:D 01.06.08 Removed Deburr EC Est Rev:E 07-12-18 RevC as per dwg ECN1048 DD verified by:EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S063	5052-H32 .063 Sheet  15.
		Comment: Qty.: 0.0656 sf(s)/Unit Total : 13.1250 sf(s) HB 8-11-24 Material: 5052-H32 (QQ-A-250/8) 0.063" thick (M5052H32S.063) Batch: <u>103713 x 120 = 7.87</u> <u>107276 x 104 = 6.82</u>
2.0	WATER JET	FLOW WATER JET 
		Comment: FLOW WATER JET 1-Cut as per Dwg D 2734 Dwg Rev: <u>C</u> HB 8-11-24 Prog Rev: <u>C</u>
		2-Deburr if necessary HB 8-11-24
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  HB 8-11-24
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK  HB 8-11-24
		Comment: SECOND CHECK S 08/11/24 X 224
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per drawing D2734 SB 08/11/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206 STEP END PLATE

Job Number: 43535

Part Number: D2734

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



current

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Cur

Cur

AS 08/12/17 x224

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/18 x224

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43535
Description: End Plate	Part Number:	D2734
Inspection Dwg: D2734	Rev: C	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>B</u>	Audited by:	<u>C</u>	Prototype Approval:	N/A
Date:	8-11-24	Date:	08/14/24	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	04.08.12	New Issue	KJ/JLM	
B	07.09.06	Dimensions added	KJ/JLM	
C	08.01.16	Dimensions revised per Dwg Rev. C	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

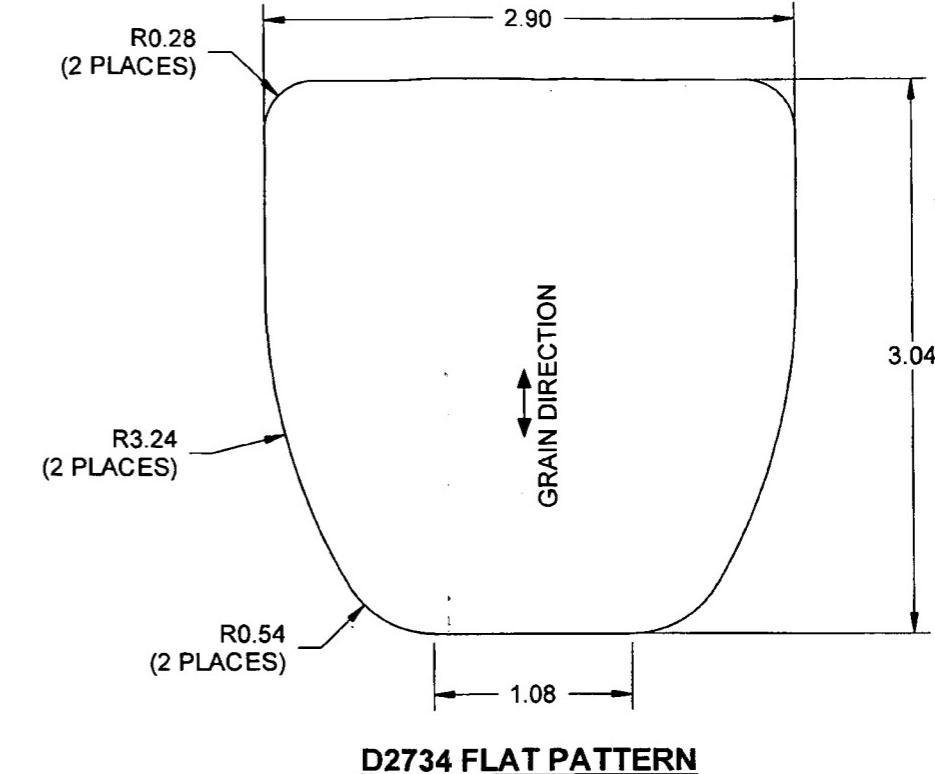
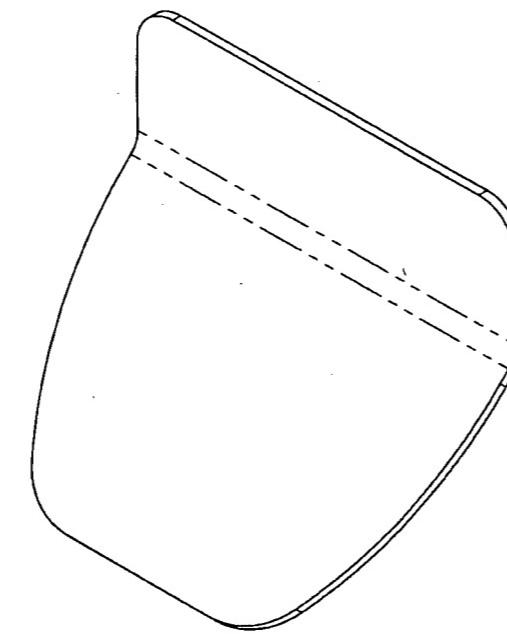
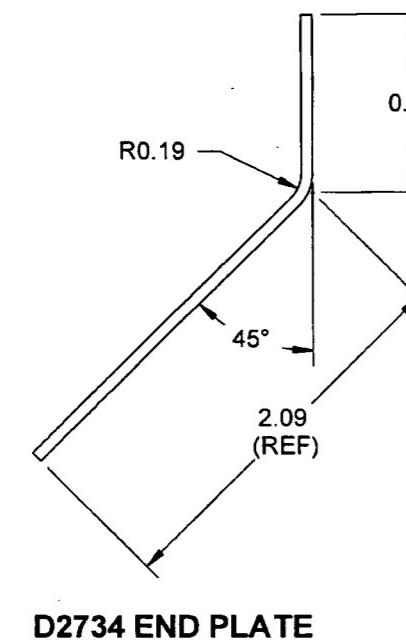
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 43535

**RELEASED**  
07.12.18  
1A

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET  
PER AMS-QQ-A-250/8 OR AMS 4016  
(REF. DART SPEC. M5052H32S.063) OR  
6061-T6 (OR 6061-T6) ALUMINUM SHEET  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lbs

C	ADD GRAIN DIRECTION NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.20
B	0.976 WAS 1.016, 2.097 WAS 2.137	KE	98.10.05
A	NEW ISSUE	KE	97.12.10
REV.	DESCRIPTION		
DESIGN	KE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. <b>D2734</b>	
CHECKED	SC	REV. C SHEET 1 OF 1	
MFG. APPR.	SC	TITLE <b>END PLATE</b>	
APPROVED	SC	SCALE 1:1	
DE APPR.	SC	DATE <b>07.11.20</b>	
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